

BENCH TYPE BOX & PAN BRAKE OPERATORS MANUAL



48" X 16GA

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Reading carefully and thoroughly the operation manual before installation and operation will ensure your machine in perfect functions and work efficient.

RECEIVING AND UNPACKING

On receiving your machine, examine if the outer packing is in good condition. Then, remove the cover to inspect whether there is any damage or loss caused during transportation. If any is found, please immediately notify the transportation and your supplier. Some parts and accessories are knocked down and in bulk packing to save transportation space. You must check those parts and accessories in extra care, and assemble them on to the machine according to the illustrations.

INSTALLATION

The machine must be installed indoors on a solid level floor. For easy operation, a space of one meter or more must be reserved on four sides of the machine. The work place must be well lighted to prevent any possible wrong operation or danger caused.

Clean the machine only with kerosens after installation.

CAUTIONS

It is strickly forbidden to bend metal sheet heavier than the rated capacity, even in shorter length.

Never use pipe extensions on Clamp Handle (2) for leverage.

Never bend against seams, It can be done only when links (7.&8) are adjusted to clamp the full multiple thickness of seam. Simultaneously, the top leaf is set back for clearance of the same full multiple thickness.

Be sure to have Angle Bar (25) mounted to leaf when making capacity bends.

CAPACITY

The capacity of the brake is determined by the bending edge thickness provided by the Angle Bar (25) when mounted on the bending leaf.

The Angle Bar(25) allows the full rated 1" flange or wider on mild steel.Narrower flanges can be bent on lighter metal.

On capacity work, the reinforcing Angle Bar must be in the normal or top position.

Capacity of brake will be reduced by four gauges if without Angle Bar.

TOP LEAF ADJUSTMENT

Clearance for bands is adjusted by moving top leaf back at bending edge. If material to be bent is within four gauges of capacity, move top leaf back twice the thickness of the material.If material is lighter,move top leaf forward proportionately depending on sharpness of bend desired.

By moving Top Leaf.unclamp Handles(2)in some degree,Then adjust Top Leaf.

Clamping pressure of the links (7&8) is changed by adjusting the Nuts(18)

JAW ALLIGNMENT

Before bending,please check if Jaws form a straight bending edge at the NoseBar(16).If not,please do in following process:Loosen Nose ClampBar Bolts (17).With Angle Bar (25) mounted,bring Bending Leaf 90° up to straighten Nose Bars in line.Then,tighten Clamp Bar bolts.

FOR RADIUS BENDS

Angle Bar (25) must be mounted to bending Leaf to bend material around RadiusNouse Bar.

REMOVABLE TOP NOSE BAR

The Nose Bars are interchangeable easily .Special types of bars

such as Radius Bars, Round Bars can be used for a variety of applications.

A full length of Nose Bar can be used to become a standard hand brake.

COUNTER BALANCE

Counter weight can be raised or lowered on Rod(28)to properly counterbalance the Bending Leaf.

OVERBENDING ADJUSTMENT

When bending sheet over further on one side than the other,move the Top Leafback on the end where sheet is overbending.Unclamping Handles(2) slightly on the side that is overbending. Then adjust Top Leaf with wobble shaft(15).Then,reclamp Handles(2).

BOWED BENDING LEAF ADJUSTMENT

If Bending Leaf becomes bowed in center after quite use,tighten both Tension Bolts until center part is in a straight line with both ends.

BENEFITS AND APPLICATIONS

The Box and Pan Brake has all the outstanding functions of the hand brake. Besides, its removable,sectioned fingers provides additional depth and clearance for wide range of uses.

The machine can form a box or pan with four sides and a bottom from one sheet of metal.

The Box and Pan Brake is mostly used in the manufacture of electric switch box,panel board cabinets. Other exetensive applications are in forming cases,buckets,carry boxes and all kinds of boxes and pans.

LUBRICATION

Lubricate occasionlly your machine with SAE-30 oil on all moving parts and into oil holes will insure smooth,trouble free operation in long time use.

PARTS LIST

PART NO.	DESCRIPTION	PART NO.	DESCRIPTION
1	NUT	16-1	FORMING FINGERS2"
2	HANDLE COVER	16-2	FORMING FINGERS3"
3	HANDLE LEFT	16-3	FORMING FINGERS4"
4	HANDLE RIGHT	17	SCREW
5	BUSH	18	NUT
6	SHAFT SLEEVE	19	KNOB BLOCK
7	SWIVEL LEFT	20	CLAMP
8	SWIVEL RIGHT	21	STAND
9	WASHER	22	BENDING LEAF
10	SCREW	23	SHAFT
11	BREAK SUPPORT	24	BUSH
12	PIN	25	ANGLE BAR
13	WASHER	26	SCREW
14	SHAFT	27	SCREW
15	WOBBLE SHAFT		(FOR 130-4816 ONLY)
		28	COUNTER WEIGHT
			(FOR 130-4816 ONLY)

